Work Orde				*956	391*						Pagé 1
Revision ID:	D2125 350/355 Floor Win	dow		Accept	*N900	<u>040</u>	100)* s	etup Sta	IV	S1* S2*
	1/16/13 St	art Qty: 4.00 eq'd Qty: 4.00	*4* *4*		Cust Item ! Customer:	ID:					
Approvals:		MLJ	Date: <u>/3-0/</u>	_ <i> 8</i> Tooling:		ate:		F	Run Sta Sto	" \	R1* R2*
Sequence ID/ Work Center ID		peration scription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	n Nbr									-
D2125	Rev C										
*100 *100* Waterjet FLOW CNC Waterje		OW WATER JET Memo 1-Cut as pe Deburr if n	or Dwg D2125 Dwg R	0.00 0.00 ev:Prog Rev	2-			9	0	and the second s	Jm13-1-25
*110 *110* QC Quality Control	QC	C2- Inspect parts off r Memo	nachine FAI/FAIB	0.00				_4_	_0_		Jon 13-1-2
*120 *120*	Qo	C8- Inspect parts - sec	cond check	0.00			(4)) 0	ع ر. •	B 13/01/28
QC Quality Control		Memo		0.00			`				1000 100

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		
			OA Closed:	Date:

										QA Closed.	Date.	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor	Engineering Quality
NCR N	lo				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data						T						
Equip/Tooling												
Operator												
Material [
Setup [
Other												
Process												
Supplier												
Training								•				
Unapproved												
					FA	AULT (CATE	GORY				
Landin	ng Gear				General		-					
	Bendir	g			Bend	G	rain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorred	ct	Weld
	Crushe	d/Crimped	-	[Burrs	In	structi	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
[Cuffs				Contamination	\square M	lainte	nance		Part Moved		-
	Heat T	eat			Countersink	Пм	lislabe	led		Positioned V	Vrong	
	Inspec	ion Strip ir	Tube		Cut Too Short	Пм	lisread			Power Loss/:	Surge	Other
[Ripple	in Bend			Drill Holes	По	ffset			•		•
	Torque	Waves in	Extrusio	n $acksquare$	Drawing	По	ut of C	alibration				
Ī	Turnin	g Sequence	:		Finish	По	ut of S	equence				
	Wave/	Twist in Tu	be		Folio	По	utside	Dimensions				

Work Ord January-17-13				*956	391*				Page 2
Item ID: Revision ID: Item Name:	D2125 350/355 Flo	oor Window		Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	1/16/13 : 1/31/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				
Approvals:		Plan:		Tooling:	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 130 *120* Thermoform Thermoforming M		Operation Description THERMOFORMING M Memo 1-Thermoforev:	rm as per folio FTA003	Set Up/ Run Hours 0.00 0.00 and dwg D2125Dwg rev	Tool ID Tool #	Plan Ac Code Qt		y I	Reject Insp. Number Stamp B 18/01/28.
*140 *140* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00					B 13/01/18
*150 *150* QC Quality Control		QC8- Inspect parts - sec Memo	ond check	0.00					3/13/01/28

										DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	·COI	NFORI	MANCE / UPDATE			
										QA Closed:	Date	:
Work Orde	er:					DISPOSITION			AGAINST	DEPARTMENT	/PROCESS	
						Rework	7		Skid-tube Crosstube	7	Water Jet	Engineering
Part I	No.				<u> </u>	Scrap		1	Machining Small Fab	Pro	d. Eng. Coor.	Quality
ALCD A						Use-as-is	4 :		noforming Finishing	Rec/Sto	re/Packaging	Other
NCR I	NO.			·		Work Order Update			Large Fab Composite		Supplier]
Root					Descr	ription of work order update		Initial	Action	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description	Date	Verification	QC Inspector
oc/Data												
quip/Tooling												
perator												
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etup												
ther												
rocess							İ					
upplier												
raining												
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							FAUL	T CATE	GORY			
Landi	ng (ı			_	General	_	1	•		_	_
		Bending			-	Bend		Grain		Ovalized	_	Pressure/Forced
	L	Centre No	ot Concer	ntric to (D/S	BOM/Route	<u> </u>	Hardwa	re	Over/Under	tolerance	Temperature/Cure
		Cracks			_	Broken/Damaged		Inspecti	on Incomplete	Part Incorre	ct	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			_	Contamination	<u></u>	Mainte	enance	Part Moved		
		Heat Trea				Countersink	<u>_</u>	Mislabe	led	Positioned \		
		Inspection	•	Tube		Cut Too Short		Misread	i i	Power Loss/	'Surge	Other
		Ripples in				Drill Holes	L	Offset				
		Torque W	aves in E	xtrusio	ր [_	Drawing		Out of 0	Calibration	~		
		Turning So	equence			Finish		Out of S	Sequence			

Outside Dimensions

Wave/Twist in Tube

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Work Orde		5691		*956	91*				Page 3
Item ID: Revision ID: Item Name:	D2125	or Window		Accept	*N90004	N100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	1/16/13 : 1/31/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				
Approvals:	Process P	lan:	Date:		Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 160 *160* Thermoform Thermoforming Ma 170 *170* QC Quality Control		Operation Description HAND FINISHING THE Memo Water sand a	and buff to remove scrac	Set Up/ Run Hours 0.00 0.00 oches as required	Tool ID Tool	# Plan Ad Code Qu	ccept Rej		Reject Insp. Number Stamp
180 *180* Packaging Packaging		Packaging Memo Wrap in cell	ophaneldentify and Stoc	0.00 0.00 kLocation:					13/4/28

												DQA:	Dat	e: _	
NCR: Y	⁄es	/ No				WORK ORDER NON-	CON	IFORM	MANCE / UP	DATE		,	· · · · · ·		
											Q/	A Closed:	Dat	e:	
Work Orde	er:					DISPOSITION				AGAINST D	EPA	RTMENT	/PROCESS		
	-					Rework	٦		Skid-tube	Crosstube	٦		Water Jet	\neg	Engineering
Part N	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	ᅱ	Quality
	-				· · · · · · · · · · · · · · · · · · ·	Use-as-is	1	Thern	noforming	Finishing			re/Packaging	ヿ	Other
NCR N	۷o. <u>-</u>					Work Order Update]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update	lr	nitial	Ac	ction		Sign &		T	
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	cription		Date	Verification	<u> </u>	QC Inspector
Doc/Data															
Equip/Tooling	\Box														
Operator	Щ														
Material															
Setup														İ	
Other													[:
Process														- 1	
Supplier															
Training															
Unapproved							<u> </u>							\Box	
						F	AUL	CATE	GORY						
Landi	ng G	iear				General	_			_	_		r		
	-	Bending			<u> </u>	Bend	\vdash	Grain		Ļ		valized		\dashv	Pressure/Forced
		Centre No	t Concer	ntric to	o/s _	BOM/Route	-	Hardwa			\o\	ver/Under	tolerance		Temperature/Cure
	-	Cracks				Broken/Damaged	Ш	Inspecti	or Incomplete	L.	Pa	irt Incorre	ct	-	Weld
		Crushed/0	Crimped.		L	Burrs		Instruct	ions Incomplete,	/Unclear	Pa	irt Lost/Mi	issing		Wrong Stock Pulled
		Cuffs				Contamination	Ш	Mainte	nance		Pa	rt Moved			
}		Heat Trea	t į			Countersink	Ш	Mislabe	eled		Po	sitioned V	Vrong		
		Inspection	Strip in	Tube		Cut Too Short		Misread	i		Po	wer Loss/	Surge		Other

Offset

Out of Ca ibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Order ID 95691 Page 4 January-17-13 1:36:16 PM Item ID: D2125 Accept *N900040100* Setup Start **Revision ID:** Stop 350/355 Floor Window Item Name: Start Qty: 4.00 **Start Date:** 1/16/13 **Cust Item ID:** Required Date: 1/31/13 **Req'd Qty:** 4.00 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Operation Insp. Work Center ID **Description** Code Qty Qty Number Stamp **Run Hours** 190 QC21- Final Inspection - Work Order Release 0.00 *190* QC⁻ 0.00 Memo Quality Control

W13:01 29

									DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPI	DATE	QA Closed:	 Date	:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	0.				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initial Chief En	i	tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved											
· · · · ·	·		•	<u> </u>	F	AULT CAT	EGORY		<u> </u>		<u>,</u>
Landin	g Gear	-			General						
	Bending Centre No Cracks Crushed/ Cuffs	Crimped.	ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs Contamination	Instru	ction Incomplete ctions Incomplete/I tenance	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ċt issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
ļ	Heat Trea				Countersink	Mislat			Positioned \		¬⊶
}-	Inspection	•	Tube	<u> </u>	Cut Too Short Drill Holes	Misre		L_	Power Loss/	Surge	Other
ŀ	Ripples in Torque W		vtrucio	<u>,</u>	Drawing	Offset	Calibration				
ļ	Turning S			'' 	Finish	—	Sequence				

Outside Dimensions

Wave/Twist in Tube

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Picklist Print

January-17-13 1:36:16 PM

Work Order ID:

95691

Parent Item:

D2125

Parent Item Name:

350/355 Floor Window

Start Date: 1/16/13

Required Date: 1/31/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: D05.10.14Added bold comments on step 5/6 & cellophane on step 7KJ/EC

IPP E 07.05.29 thermoformed in-house

e EC

EC verified by:DD

123949

Component Item ID/ Item Name	Replacement Item ID	rev C dwg Mfg/ Purch	Bin Item	EC verification Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			120	sf	518.7445	1.664	2.0063156 7.5			JM13-1-
				Location		Loc Qty	Lo	c Code					
				MAT019		518.7445							
				123	704	79			123	704			
				123	895	343.7445							

96

											DQA:	Date	<u> </u>
NCR:	Yes	/ No				WORK ORDER NON-	-COI	VFOR	MANCE / UPI		QA Closed:	Date	
Nork Ord	er:					DISPOSITION				AGAINST DEI			
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCK I	VO.					work Order opdate[_			Large Fab	Composite		Supplier	_
Root Cause		Date	Step	Qty	Desc	cription of work order update or Non-conformance		nitial iief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining									Descri		Jule	·	qe mspector
			l	<u> </u>	L		FAUL	T CATE	GC)RY			<u> </u>	
Landi	ng (Gear			_	General		•			•		
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped, t n Strip in		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		1	ion Incomplete ions Incomplete/U enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W		xtrusio	n	Drawing		1	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

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DART AEROSPACE LTD	Work Order:	95691
Description: Floor Window	Part Number:	D2125
Inspection Dwg: D2125 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.78	+1-0-030"	17.70"	-		7	Jkmss
13.28	t1-0.030°	17.76° B.26°	-		Î	
0.125	+1-0-030" +1-0-010"	0.126"			J	Jamo.
				- W.		·
	-					

Measured by:	Jm	Audited by:	15	Preliminary Approval:	
Date:	13-1-25	Date:	13-1,58	Date:	

Rev	Date	Change	Revised by Approved
Α	12.07.31	New Issue	KJ 🛠

